

Work Order ID 134717

Friday, July 17, 2015 8:02:47 AM

134717

Page 1

Item ID: D3192-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pod Assembly
 Start Date: 7/17/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/17/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUL 17 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3192	C

100 PURCHASING 0.00

100

Purchasing 30194 0.00

Purchasing

Memo
 Issue P/O: 29204
 Description:
 D2200-1 Pod Lid
 D2200-3 Pod Base
 Supplier: Delastek EDC
 Copy of Certificate of Conformity and Process sheet from Delastek is required.

151020

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo
 Ensure Certificate of Conformity and Process sheet from Delastek is attached.

1X 8015-11-9

see attached
 email from DS for
 substitution
151026

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>134717</u> Part No. <u>03192-042</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐			
Date: <u>15.11.11</u>		Step #: <u>130</u>		QTY Effective: <u>2</u>		MRB (QSI042) Approval <u>A.P.</u> <u>15.11.11</u>	
Description Work Order Deviation <u>03191-3 @ 8.91 instead of 10.91.</u>				Disposition <u>ACCEPTABLE BASED ON TEST FIT TO HARD POINT ON BELL 205 AIRFRAME. OPEN PAR</u> <u>Dimension 10.91 will position the bracket 02193-1 at the curved section of the pod</u> <u>test was perform bulg Alex & Sylvain</u> <u>PAR 15 475 open.</u>			
				Completed By <u>SMB</u> <u>15/11/11</u>			
				Lead hand / Supervisor Approval Verification <u>DAS</u> <u>9</u> <u>9-89</u> <u>18-01-15</u>			
				QC / QA Coordinator Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>16-01-15</u>			
Root Cause Environment ☐ Design ☒ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☒ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☒ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER: _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
WAS Found at inspection of PDC that Pod is 1" longer than Drawing								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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134717

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Pod Assembly

Stop *NS2*

Start Date: 7/17/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/17/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Bill Date: 16/02/18Work Order update only ☐

Work Order: <u>134717</u> Part No. <u>D3192-042</u> NCR No. <u>16-5592</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☐																																																
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Work Order ID 134717

Friday, July 17, 2015 8:02:47 AM

134717

Page 4

Item ID: D3192-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pod Assembly
Start Date: 7/17/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/17/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 15-11-23
MLJ 15-11-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>134717</u> Part No. <u>D3192-042</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☒</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☒	Supplier ☐																																																																																																																	
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		OTHER: _____																																																																																																																																					

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Page 1

Work Order ID: 134717

Parent Item: D3192-042

Parent Item Name: Pod Assembly

134717

D3192-042

Start Date: 7/17/2015

Required Date: 7/17/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 08.07.17 DL
IPP rev:B 09-02-05 rev.B as per dwg DD verified by:EC IPP revC
11.07.21 revC dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2200-1		Manufactured	No			100	Each	0.0000	1	1			
D2200-1									**				
Pod Lid													
D2200-3		Manufactured	No			100	Each	0.0000	1	1			
D2200-3									**				
Pod Base													
D4393-17		Manufactured	No			100	Each	0.0000	1	1			
D4393-17									**				
Piano Hinge													
AN4-6A		Purchased	No			130	Each	1,122.000	1	1			
AN4-6A									**				
BOLT													

Location

Loc Qty

Loc Code

CA	143	
M128403	43	
M130851	100	
ST325A	971	
M131153	971	
ST345	8	
M128403	8	

SEP 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

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Page 2

Work Order ID: 134717

Parent Item: D3192-042

Parent Item Name: Pod Assembly

134717

D3192-042

Start Date: 7/17/2015

Required Date: 7/17/2015

Start Qty: 1.00

Required Qty: 1.00

D2569

Manufactured No

130

Each

3.0000

1

1

D2569

Hinge

**

W/A

Location

Loc Qty

Loc Code

CA2

3

125408

2

132295

1

AD64ABS

Purchased No

150

Each

180.0000

38

38

AD64ABS

Pop Rivet

**

SMB
15/11/19

Location

Loc Qty

Loc Code

CCK004

180

M128728

180

AN3-11A

Purchased No

150

Each

104.0000

30

30

AN3-11A

Bolt

**

SAS
27
9-89

Location

Loc Qty

Loc Code

ST338a

104

m125709

104

AN3-5A

Purchased No

150

Each

258.0000

30

30

AN3-5A

Bolt

**

SAS
27
9-89

Location

Loc Qty

Loc Code

CA

132

m129682

132

GA

126

m131420

126

M133234

SAS
27
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Work Order ID: 134717

134717

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 7/17/2015

Required Date: 7/17/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-11A Purchased No

150 Each 92.0000 6 6

AN4-11A

BOLT

**

BAS
27
9-89

Location	Loc Qty	Loc Code
FG	20	
120731	20	
ST325A	72	
M128362	72	

AN4-5A Purchased No

150 Each 148.0000 13 13

AN4-5A

BOLT

**

BAS
27
9-89

Location	Loc Qty	Loc Code
CA	55	
m129682	55	
ST345	93	
6651	1	
m132317	92	

AN526C632R7 Purchased No

150 Each 153.0000 2 2

AN526C632R7

Screw

**

BAS
27
9-89

Location	Loc Qty	Loc Code
ST329	153	
m129339	153	

D2198-1 Manufactured No

150 Each 22.0000 6 6

D2198-1

Bracket

**

BAS
27
9-89

Location	Loc Qty	Loc Code
Mezz	22	
124818	4	
125741	6	
62674	12	

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Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 4

Work Order ID: 134717

134717

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 7/17/2015

Required Date: 7/17/2015

Start Qty: 1.00

Required Qty: 1.00

D2204-6

Manufactured No

150

Each

22.0000

3

3

D2204-6

Latch

**

BAS
27
9-89

Location

Loc Qty

Loc Code

Mezz

22

126169

18

67120

4

3

D2204-9

Manufactured No

150

Each

12.0000

2

2

D2204-9

Rubber Latches

**

BAS
27
9-89

Location

Loc Qty

Loc Code

ST488a

12

131885

12

2

D2258-220

Manufactured No

150

Each

5.0000

1

1

D2258-220

Placard

**

BAS
27
9-89

Location

Loc Qty

Loc Code

ST005

5

41266

1

84458

4

B139274

1

D2429-041

Manufactured No

150

Each

8.0000

1

1

D2429-041

Spring Clip Ass'y

**

BAS
27
9-89

Location

Loc Qty

Loc Code

ST007

8

107585

2

124757

6

1

SEP 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>134717</u> Part No. <u>D3192-042</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☒ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐							
Date: <u>15.11.19</u>		Step #: <u>130</u>		QTY Effective: <u>①</u>		MRB (QSI042) Approval <u>A.P.</u> <u>15.11.19</u>					
Description Work Order Deviation <u>D2528-3 BACKEN PLATES ON OUTWARD OF POD TRIMMED TO PREVENT OVERLAP (QTY 2)</u>				Disposition <u>ACCEPTABLE PROVIDED EDGE DISTANCE IS MAINTAINED (2D) ALODINE, PRIMER & PAINT</u>				Completed By <u>Smt 16/1/21</u>			
				Lead hand / Supervisor Approval Verification DAS 9 16-01-16 9-89							
				QC / QA Coordinator Approval <u>5/16/15</u>							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ ☒ Manufacturing Process Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ ☒ Fit/Function Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____											

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Work Order ID: 134717

134717

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 7/17/2015

Required Date: 7/17/2015

Start Qty: 1.00

Required Qty: 1.00

D2463 Manufactured No 150 f 507.9568 14.167 14.91263

D2463

1/2" Seal (\$Per Foot)

**

SMB

Location

Loc Qty

Loc Code

ST409

39.9568421

115701

39.9568421

ST638

468

125469

468

M128447

14.91263

D2528-1

Manufactured No

150 Each

3.0000

5

5

D2528-1

Backer Plate

**

BAS
27
9-88

Location

Loc Qty

Loc Code

ST007

3

128878

1

132296

2

B134119

2

3

D2528-3

Manufactured No

150 Each

7.0000

4

4

D2528-3

Backer Plate

**

BAS
27
9-88

Location

Loc Qty

Loc Code

ST007

7

132297

7

4

D3007-041

Manufactured No

150 Each

2.0000

1

1

D3007-041

Prop Assy

**

BAS
27
9-88

Location

Loc Qty

Loc Code

ST368

2

132298

2

1

K10019

Manufactured No

150 Each

0.0000

1

1

K10019

Bracket Assembly

**

B134720

SEP 28 2015

Friday, July 17, 2015 8:02:52 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>134717</u> Part No. <u>123192-042</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☒ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality Other ☐					
Date : <u>15.11.19</u>		Step #: <u>130</u>		QTY Effective : <u>①</u>			MRB (QSI042) Approval <u>A.P.</u> <u>15.11.19</u>		
Description Work Order Deviation <u>D2461 SEAL USED INSTEAD OF D2463 SEAL</u>				Disposition <u>ACCEPTABLE DEVIATION, MATERIAL IS THE SAME ∴ ADHESIVE STRENGTH UNAFFECTED. ORIGINAL DESIGN INTENT IS NOT AFFECTED. NO EFFECT ON FIT, FORM OR FUNCTION.</u> <u>PARIS-475</u>				Completed By <u>SMB</u> <u>15/11/19</u> Lead hand / Supervisor Approval Verification <u>DAS</u> <u>9</u> <u>9-89</u> <u>16.01.16</u> QC / QA Coordinator Approval <u>6/16/15</u>	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☒ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ ☒ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

Picklist Print

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Page 6

Work Order ID: 134717

134717

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 7/17/2015

Required Date: 7/17/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L06

Purchased

No

150

Each

144.0000

2

2

MS21042L 06

Nut

**

AS
27
8-89

Location

Loc Qty

Loc Code

ST304

1

m131294

1

ST305

143

m129499

3

m131317

140

MS21042L3

Purchased

No

150

Each

1,245.000

60

60

MS21042L 3

Nut

**

AS
27
8-89

SEP 28 2015

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

374

M131317

374

ST305

478

116549

12

126333

49

M128754

2

M132123

17

M132382

398

m133/34

60

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, July 17, 2015 8:02:54 AM

Page 7

Work Order ID: 134717

134717

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 7/17/2015

Required Date: 7/17/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

150

Each

3,780.000

20

20

MS21042L4

Locknut

**NAS
27
9-89**

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

142

m127813

142

ST260a

3456

m129472

8

m130799

56

m131803

6

m132262

386

m132382

3000

ST305

180

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

NAS1149D0363J

Purchased

No

150

Each

1,935.000

60

60

NAS1149D0363J

Washer

**NAS
27
9-89**

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

1098

m128429

134

m132677

964

ST269

268

m126319

7

m131618

1

m132317

260

m13037

60 + 60

SEP 28 2015

Friday, July 17, 2015 8:02:54 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>134717</u> Part No. <u>03192 042</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☒ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date: <u>15.11.18</u>		Step #: <u>130</u>		QTY Effective: _____			MRB (QSI042) Approval <u>A.P.</u>				
Description Work Order Deviation <u>AN3 BOLTS IN VARIOUS LOCATION TOO LONG REPLACED WITH SHORTER LENGTH</u> <u>R.C. process. Thickness of pad will varie during fabrication.</u>				Disposition <u>ACCEPTABLE TO REPLACE AN3 BOLTS WITH LONGER OR SHORTER LENGTHS AS REQUIRED TO ENSURE 2-4 THREADS EXPOSED PAST THE NUT.</u> <u>ACCEPTABLE TO ADD NAS1149D036@S UNDER NUT. AS REQUIRED</u>				15.11.18 Completed By <u>SM</u> <u>15/11/19</u> Lead hand / Supervisor Approval Verification <u>DAS</u> <u>9</u> <u>9-89</u> <u>16/01/16</u> QC / QA Coordinator Approval <u>6</u> <u>16/01/16</u>			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ ☒ Process Improvement ☒ Manufacturing Process Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐						Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ ☒ Finish Misread ☐ Turning Sequence ☐	
OTHER : _____											

Picklist Print

Friday, July 17, 2015 8:02:54 AM

Page 8

Work Order ID: 134717

134717

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 7/17/2015

Required Date: 7/17/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

150

Each

4,028.000

21

21

NAS1149D0463.J

WASHER

NAS
27
8-89

Location

Loc Qty

Loc Code

GA

53

M129390

53

ST260a

1000

M132677

1000

ST269

2975

M129682

86

M130799

371

M132035

2361

M132317

157

21

NAS1149DN632J

Purchased

No

150

Each

307.0000

2

2

NAS1149DN632.J

Washer

NAS
27
8-89

Location

Loc Qty

Loc Code

ST270

307

M127255

11

M128812

49

M132317

47

M132677

200

2

SEP 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

ITEM	Qty -041	Qty -042	PART NUMBER	DESCRIPTION
1	X		D3192-041	UTILITY POD ASSEMBLY, LH
2		X	D3192-042	UTILITY POD ASSEMBLY, RH
5			D3192-1	DELETED AT REVISION C
9	1	1	D2195	BRACKET
10	1	1	D2196	BRACKET
11	1	1	D2197	BRACKET
12	6	6	D2198-1	BRACKET
13	1	1	D2200-1	POD LID
14	1	1	D2200-3	POD BASE
15	3	3	D2204-6	LATCH
16	2	2	D2204-8	LATCH
17	1	1	D2258-220	PLACARD
18	1	1	D2429-041	SPRING CLIP ASSEMBLY
19	1	1	D2493-1700	NEOPRENE SEAL
20	5	5	D2528-1	BACKER PLATE
21	4	4	D2528-3	BACKER PLATE
30	1	1	D3007-041	PROP ASSEMBLY
31	2	2	D3191-1	BACKER PLATE
32	3	3	D3191-3	BACKER PLATE
33	1	1	D3191-5	BACKER PLATE
34	1	1	D4393-17	PIANO HINGE
40	38	38	AD64ABS	RIVET
41	30	30	AN3-11A	BOLT
42	30	30	AN3-5A	BOLT
43	6	6	AN4-11A	BOLT
44	13	13	AN4-5A	BOLT
45	1	1	AN4-6A	BOLT
46	2	2	AN528C632R7	SCREW
47	60	60	AN980JD10	WASHER
48	21	21	AN980JD416	WASHER
49	2	2	AN980JD6	WASHER
50	2	2	MS21042L06	NUT (OR MS21042-06)
51	60	60	MS21042L3	NUT (OR MS21042-3)
52	20	20	MS21042L4	NUT (OR MS21042-4)

NOTES:

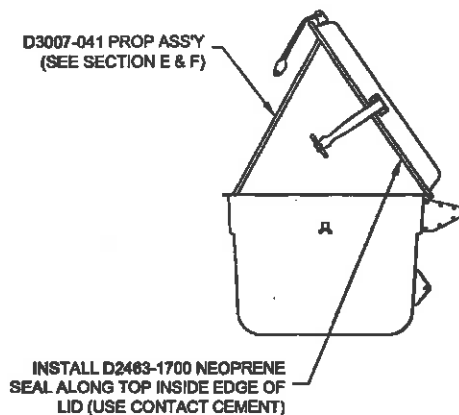
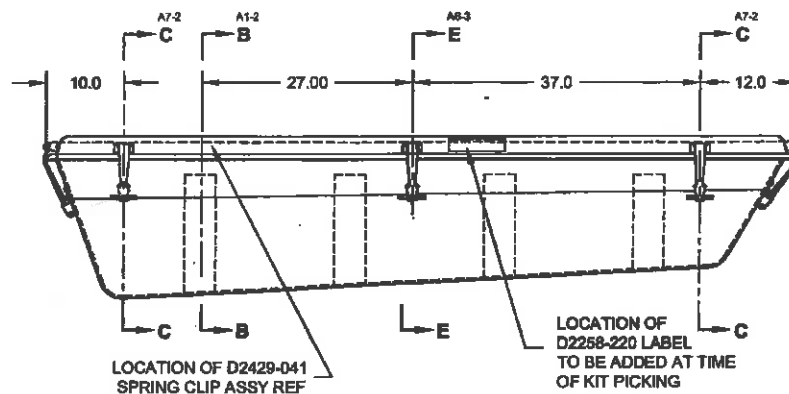
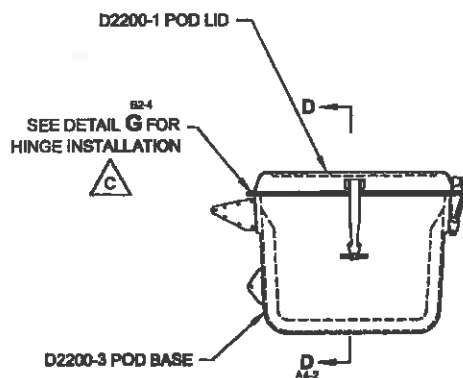
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 54 lbs APPROX
- 8) SEAL ALL HOLES AND EDGES OF POD LID (ITEM 13) AND BASE (ITEM 14) WITH CYANOACRYLATE GLUE.
- 9) FOR INSTALLATION OF D4393-17 HINGE:
 - (i) TRANSFER MARK AND DRILL POD LID (ITEM 13) AND BASE (ITEM 14) Ø0.191.
 - (ii) INSTALL RIVET HEADS FROM OUTSIDE OF POD.
 - (iii) GRIND TRAILING EDGE OF RIVET TO 0.100 IN HEIGHT TO PERMIT HINGE TO CLOSE.
- 10) FOR HOLES DRILLED THROUGH FOAM CORE:
 - a) DRILL Ø0.313" HOLES THROUGH POD.
 - b) CLEAN OUT FOAM Ø0.250" AROUND HOLE BETWEEN INNER AND OUTER SKINS.
 - c) APPLY TAPE TO UNDERSIDE OF SKIN (TO STOP EPOXY FILLER GOING THROUGH).
 - d) FILL CAVITY BETWEEN SKINS COMPLETELY WITH "HYSOL EA834" OR SIMILAR EPOXY POTTING COMPOUND.
 - e) AFTER THE EPOXY HAS COMPLETELY CURED, DRILL Ø0.257 FINISH HOLE SIZE FOR AN4 BOLT OR Ø0.191 FINISH HOLE SIZE FOR AN3 BOLT.
- 11) RELIEVE D2200-1 POD LOCALLY IN AREA OF D2195/D2198/D2197 BRACKETS TO CLEAR BRACKETS.
- 12) INSTALL D3191-1/3/5 BACKER PLATE USING SIKAFLEX -241/291 ADHESIVE.

RELEASED
2011-05-20

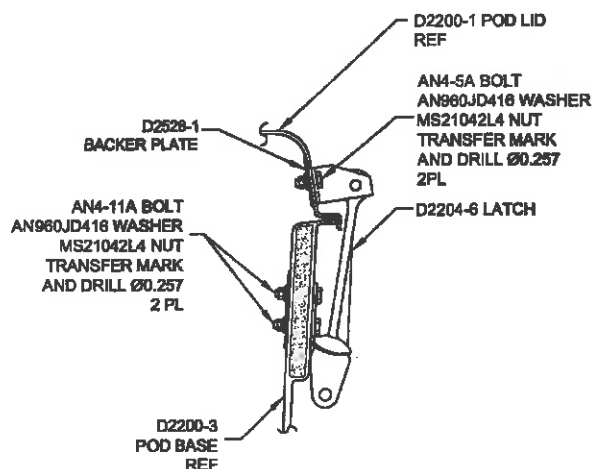
134717 MJS
150717

C	ADDED SHT 5. MOVED VIEWS FROM SHT 4 TO SHT 5. SHT 1 DELETED ITEM 5, ADDED ITEM 34. SHT 4 ADDED DETAIL G & DETAIL H. (SEE CAR 11-040).	AJS	11.05.05
B	DRAWING TRANSFERRED TO "B" SIZE AND REDRAWN WITH CURRENT STANDARDS. -1 HINGE ADDED. ADDED ITEM 33 (SEE NCR 08-110).	AJS	09.01.05
A	NEW ISSUE	DS	03.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	S	DRAWING NO.	REV. C
MFG. APPR.		D3192	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	11.05.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

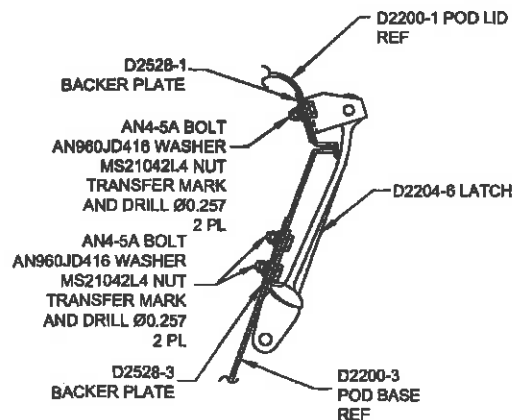
8 7 6 5 4 3 2 1



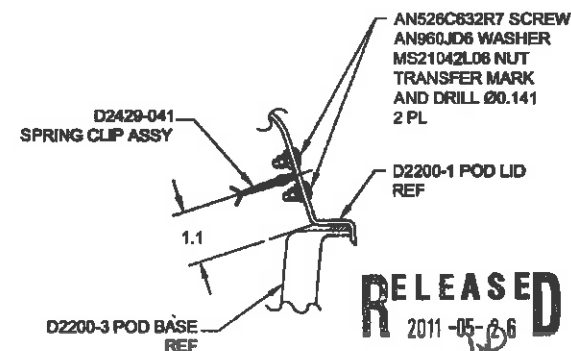
D3192-041 UTILITY POD ASSEMBLY, LH (SHOWN)
D3192-042 UTILITY POD ASSEMBLY, LH (OPPOSITE)



SECTION C-C D3-2
SCALE 4X D6-2



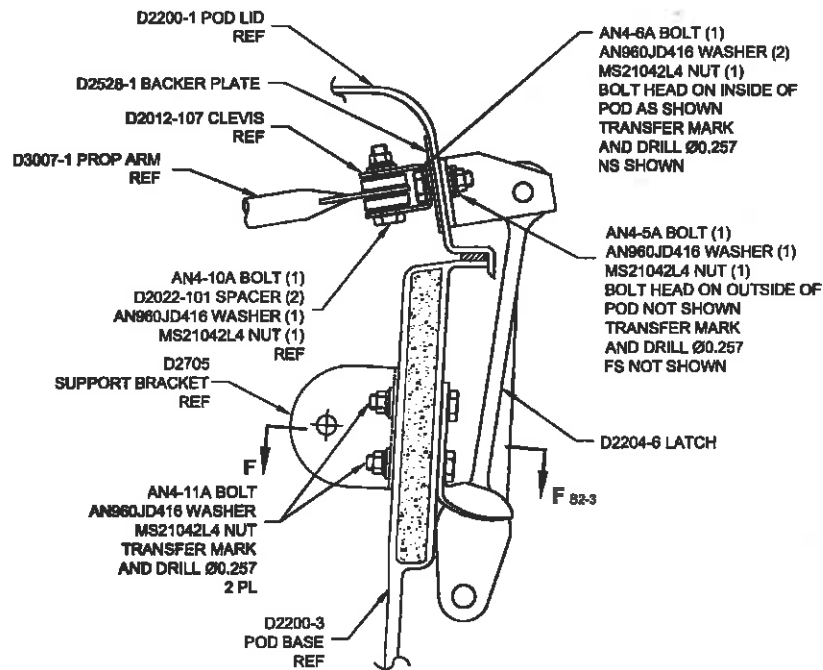
SECTION D-D C7-2
SCALE 4X



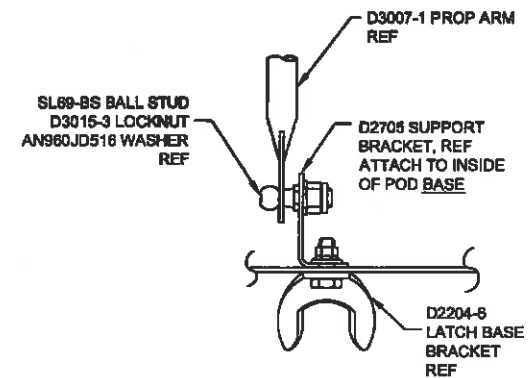
SECTION B-B D6-2
SCALE 6X

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3192	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	11.05.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



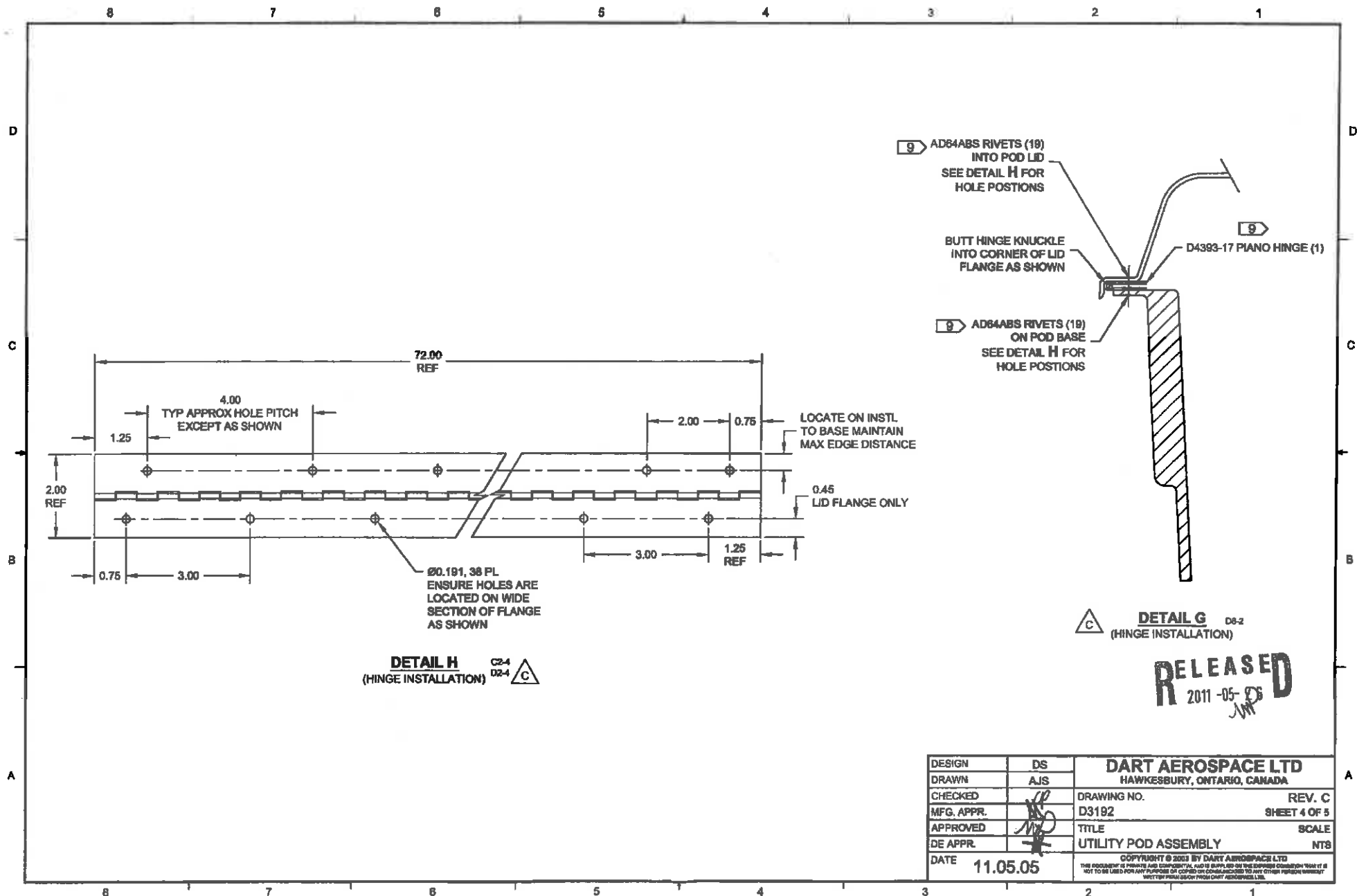
SECTION E-E D4-2

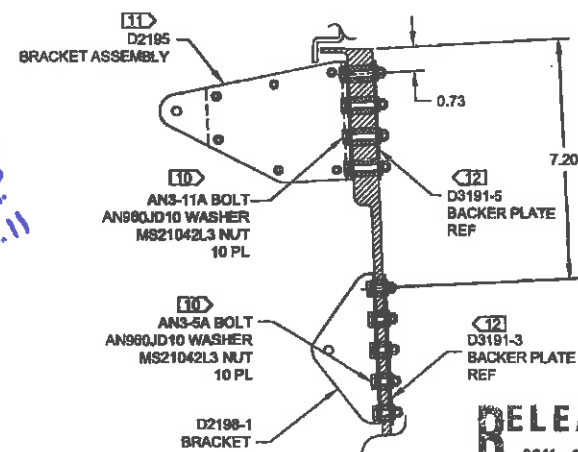
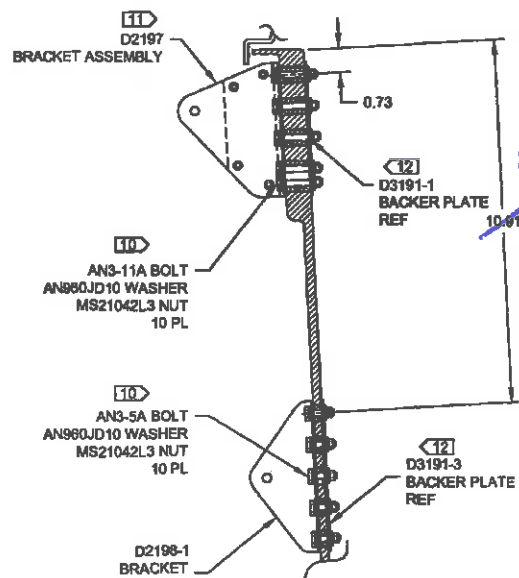
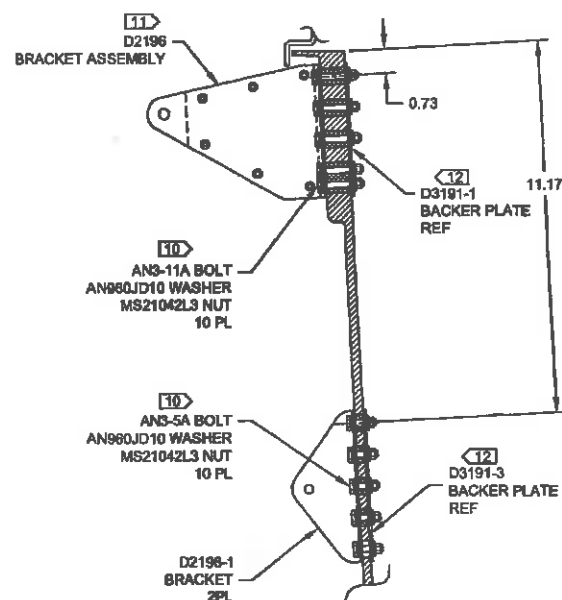
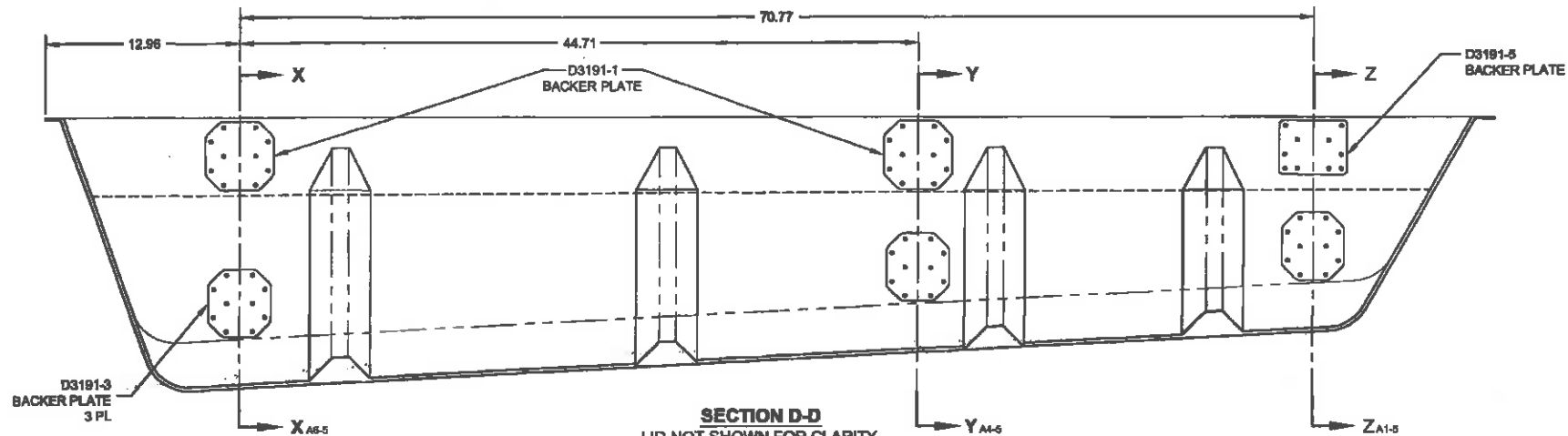


SECTION F-F C6-3
ROTATED 85° CW

RELEASED
2011-05-26

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3192	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	11.05.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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RELEASED
2011-05-26

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3192	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTB
DATE	11.05.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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NOTES:**1) MATERIALS:**

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE-CELL, OR DIVINYCELL, OR KLEGECELL, OR
AIREX, 0.38 THICK (3/8" FOAM)FIBER: 9.7oz 7781 WEAVE "S" GLASS (9oz SATIN)
5oz PLAIN WEAVE KEVLAR (5oz KEVLAR)
12oz UNIDIRECTIONAL (12oz UNIDIRECTIONAL)
OWENS CORNING MILLED FIBERS, "E" GLASS

FILLER: MIXTURE OF RESIN AND MILLED FIBERS

EXPANDING FOAM: DEMILEC B352-0 / A100-4 (LIQUID FOAM)

2) FINISH: -INSIDE: DUPONT HIGHBUILD GREY PRIMER 7704S
-OUTSIDE: WHITE GELCOAT #3EL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

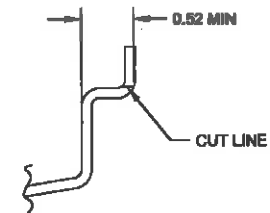
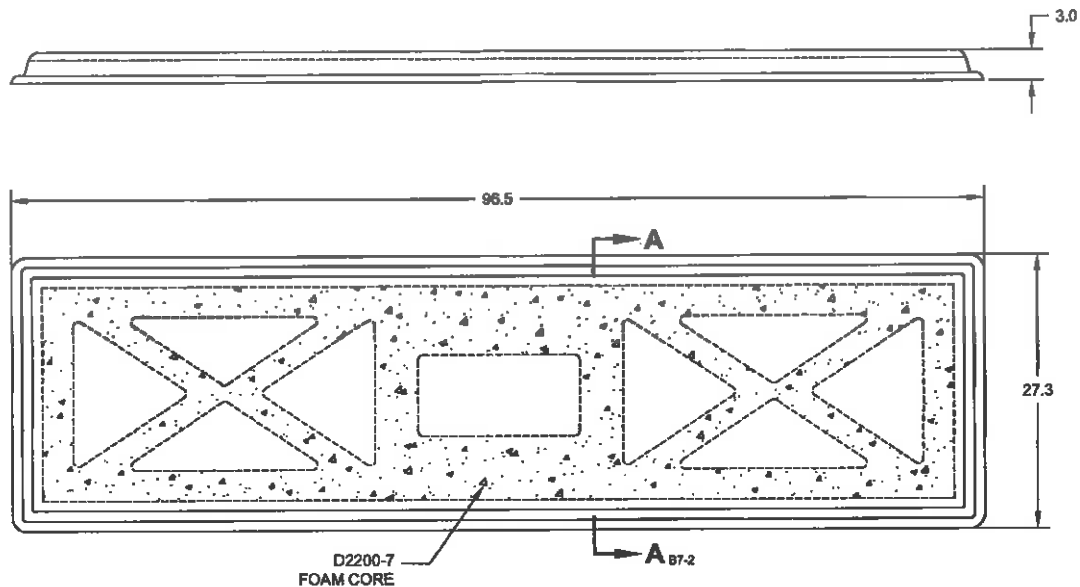
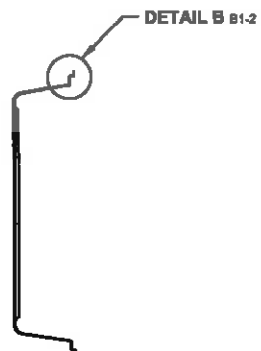
8) LAMINATE PER DART QSI 008
LAMINATION SCHEDULE PER THIS DRAWING.

9) PEEL PLY ALL SURFACES.

*cd0134777***RELEASED**
2011-05-26
MT

C	SHT 3, ZONE D5 DIM WAS 86.0, ZN B5 DIM WAS 27.0, ZN D6, MOLD DATUM RELOCATED TO FIXED POINT FOR CLARITY. (SEE CAR 10-28)	AJS	11.04.20
B	DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 1 EXPANDING FOAM MATERIAL WAS GELCOTE VULTAFOAM W9900 A/B, FINISH SPEC UPDATED. MULTIPLE DIMS ON MULTIPLE SHEETS CHANGED FROM REF TO "HARD" CALLOUTS. SHT 2 D2200-7 WAS D2202-7 (TYPO). VIEWS FROM SHT 5 TRANSFERRED TO SHT 4. D2200-7 DETAILED ON SHT 5.	AJS	08.08.18
A	NEW ISSUE	JB	03.05.21
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2200	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD LID AND BASE (212)	NTS
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SECTION A-A B4-2



DETAIL B B4-2
SCALE 10X

D2200-1 LID
(MOLD DT8007)

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2200-7 FOAM CORE
5oz KEVLAR
9oz SATIN

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2011-05-26
AM

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2200	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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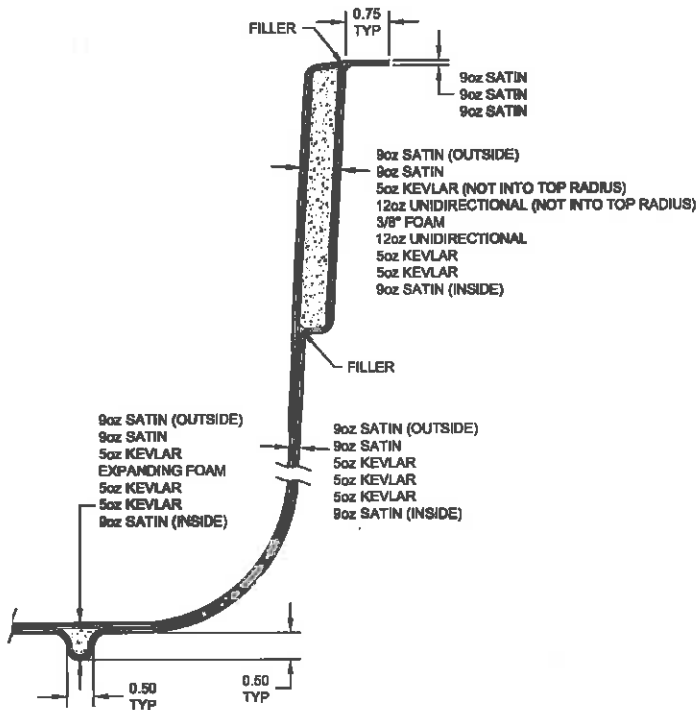


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2011-05-26

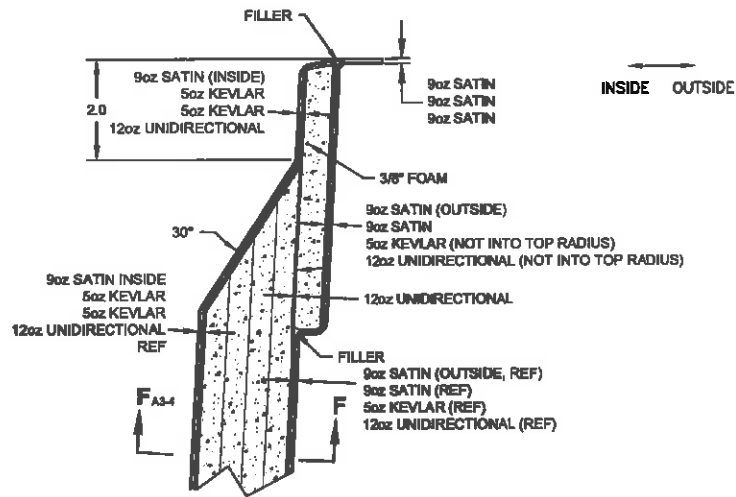
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2200	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

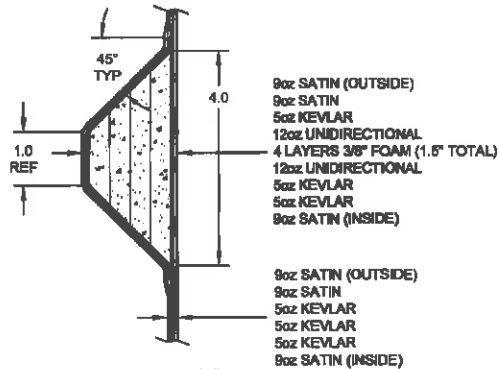
INSIDE OUTSIDE



SECTION D-D C4-3
(PART SECTION OF WALL SHOWN)



SECTION E-E C3-3
(PART SECTION OF WALL SHOWN)

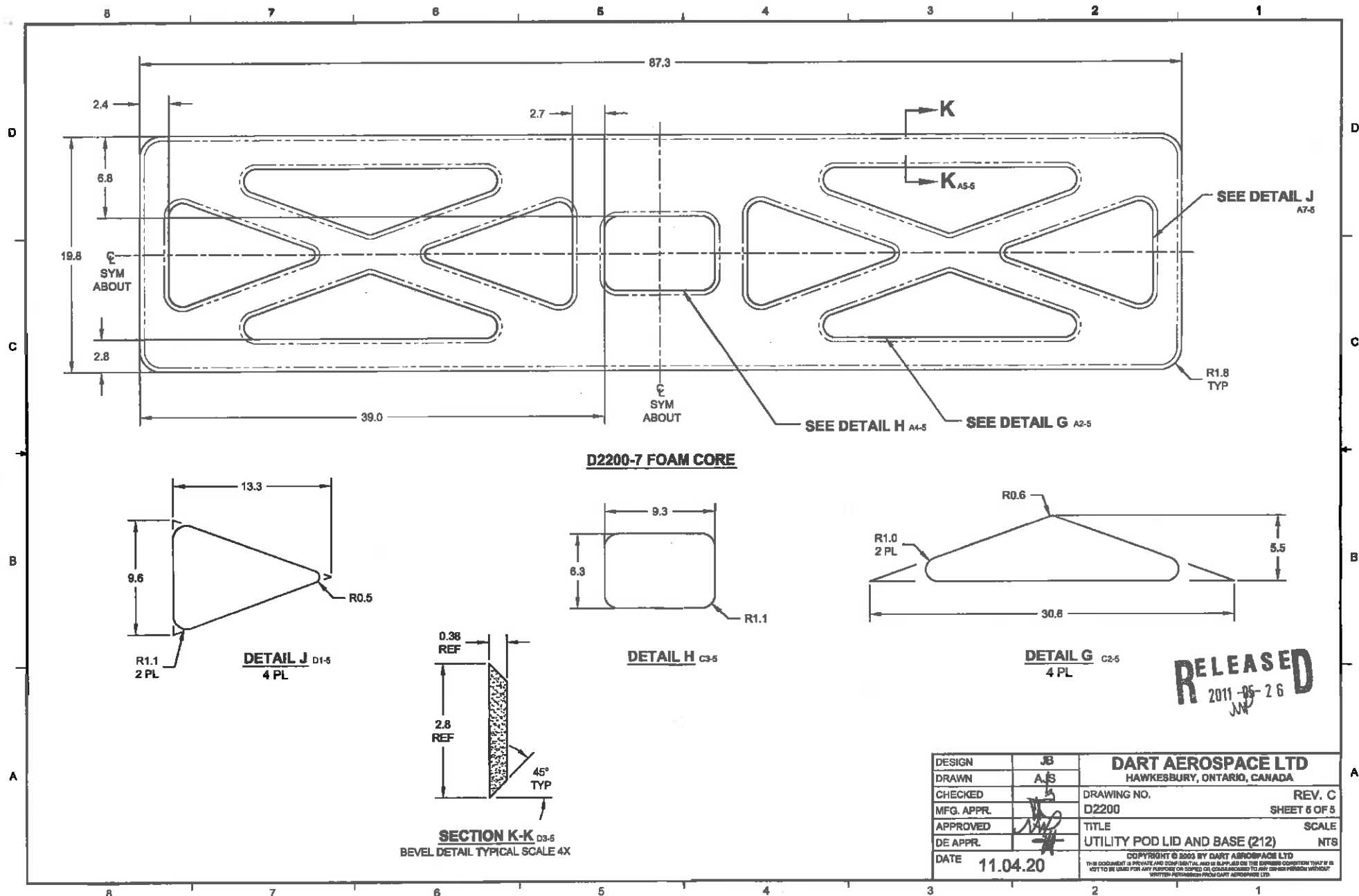


SECTION F-F C4-4

RELEASED
2011-05-26
WJ

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2200	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD LID AND BASE (212)	NTS
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8 7 6 5 4 3 2 1



RELEASED
2011-05-26
JW

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2200	REV. C
MFG. APPR.		SHEET 6 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD LID AND BASE (212)	NTS
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Linda Lacelle

From: David Shepherd
Sent: Monday, October 26, 2015 1:14 PM
To: Linda Lacelle; William Monterroza
Subject: RE: Expanding foam versus resin and milled fibers

Linda,

Sorry for the delay. The requested substitution is acceptable to Dart, as long as the weight of the pod is not increasing.

Regards,
David

From: Linda Lacelle
Sent: October-23-15 2:04 PM
To: David Shepherd <dshepherd@dartaero.com>; William Monterroza <wmonterroza@dartaero.com>
Subject: Fwd: Expanding foam versus resin and milled fibers

Guys??? I need to know asap! This pod is already a month late if not more due to Delastek.

Thx
L

Sent from my iPhone

Begin forwarded message:

From: Karim Malihy <malihyk@fdccomposites.com>
Date: October 23, 2015 at 3:40:42 PM EDT
To: llacelle@dartaero.com
Cc: Sylvain Santerre <santerres@fdccomposites.com>, Carl Beliveau <beliveauc@fdccomposites.com>, Stéphane Pageau <pageaus@fdccomposites.com>
Subject: Expanding foam versus resin and milled fibers

Hello Linda,

My question is what we can replace the expanding foam by resin and milled fibers for utility pod part D2200, see the attached document for more detail.

Thank you.

Karim Malihy .Ing/Eng
Chargé de projets

Engineering Project Manager

FDC Composites Inc.

45, Chemin de l'Aéroport (112)

Saint-Jean-sur-Richelieu, Québec, Canada J3B 7B5

Tel: 450.357.1344 #402

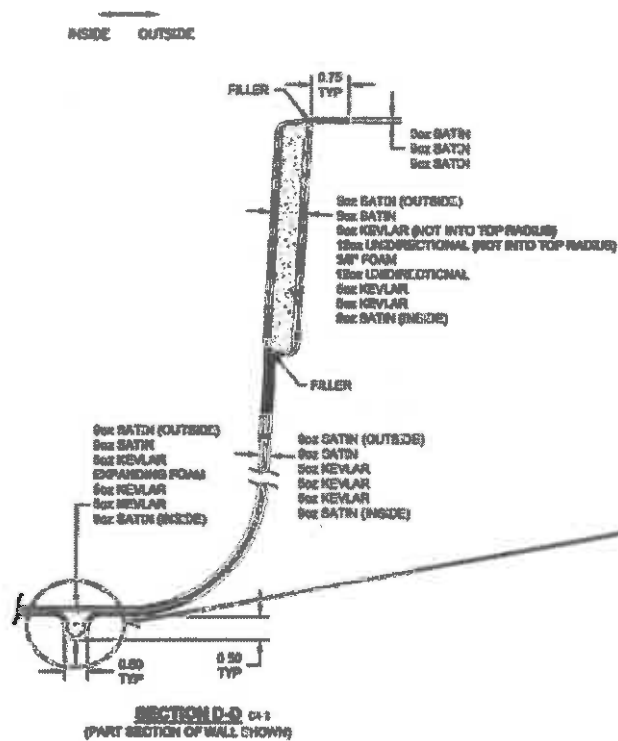
Cell: 514.703.1344

Fax : 450.357.1194

malihyk@fdccomposites.com <paquettebellemarep@fdccomposites.com>
www.FDCcomposites.com <<http://www.fdccomposites.com/>>

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Utility pod lid and base (212), drawing No D2200 :

Replace the expanding foam by resin and milled fibers.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30194**

Purchase Order Date 10/20/2015

PO Print Date 10/23/2015

Page Number 1 of 3

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2200-1P PER DRWG D2200 REV.C	Pod Lid	11/10/2015 Yes 11/10/2015		1.00 Each ✓	\$3,100.00	\$3,100.00
						Line Total:	\$3,100.00
2	D2200-3P PER DRWG D2200 REV.C	Pod Base	11/10/2015 Yes 11/10/2015		1.00 Each ✓	\$3,100.00	\$3,100.00
						Line Total:	\$3,100.00

2015-11-9

Note:

10/23/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30194**

Purchase Order Date 10/20/2015

PO Print Date 10/23/2015

Page Number 2 of 3

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344 ext303

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

3	71401-45	Procurement Quality Clause	11/10/2015	1.00	✓	\$0.00	\$0.00
---	----------	----------------------------	------------	------	---	--------	--------

No

11/10/2015

Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A016 personnel qualification

A025 certification of conformance

A040 notification of quality escape

A041 quality management

A042 dart notification by supplier

A043 retention of quality documents

Line Total: \$0.00

4	71550-15	Drilling and cutting jigs	11/10/2015	1.00	✓	\$900.00	\$900.00
			No				
			11/10/2015				

Line Total: \$900.00

5	71525-20	Repairs to 212 pod molds (DT8007 lid, DT8001, base)	11/10/2015	1.00	✓	\$700.00	\$700.00
			No				
			11/10/2015				

Note:

8015-11-9

10/23/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30194**

Purchase Order Date 10/20/2015

PO Print Date 10/23/2015

Page Number 3 of 3

Order From :

VC-FDC01

Ship To : DART AEROSPACE LTD

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-357-1344 ext303

Buyer

Linda Lacelle

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Line Total: \$700.00

PO Total: \$7,800.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 5

Change Date: 10/23/2015

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél.: 450 357-1344

Bon de livraison

05/11/2015

Commande : 2285
Référence : PO #30194/1-5

Client : Dart

Expédier à

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Même

Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D2200-1P ✓	POD LID PO item: 30194/1 Lot: 2015-10-27	✓ 1	_____	_____
D2200-3P ✓	POD BASE PO item: 30194/2 Lot: 2015-10-27	✓ 1	_____	_____
71550-15 ✓	Drilling and Cutting Jigs	✓ 1	_____	_____
71525-20 ✓	Repaires to 212 pod molds DT8007 lid DT8001 base	✓ 1	_____	_____

8015-11-9

Transport : _____

Réf. : _____

Nb colis : _____

Marchandise reçue : _____

CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 30194

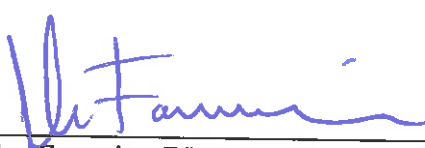
<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>FDC Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>Lot</u>
1	1	D2200-1P	DAE005-001	D2200 Rev. C	Pod Lid	2015-10-27 ✓
2	1	D2200-3P	DAE006-001	D2200 Rev. C	Pod Base	2015-10-27 ✓

FAI articles.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

SP15-11-9

Signature:


Jules Fournier, BDI, Quality Manager

Date: 2015-11-05